

Work Order ID 68561

Monday, April 18, 2011 6:56:04 AM



Page 1

Item ID: D3407-5

Accept



Setup

Start



Revision ID:

Item Name: Ring

Stop



Start Date: 4/18/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3407	Rev E

100



FLOW WATER JET

Waterjet

Memo

0.00

B41-4-18

FLOW CNC Waterjet

1-Cut as per Dwg D3407

Dwg Rev: FProg Rev: F

2-Break edges on grinder as per Dwg D3407

⇒ m-f 11/04/19 (28X)

(28)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B41-4-18

Quality Control

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Setup

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Start Date: 4/18/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

Count



Quality Control

130

Identify as per dwg & Stock Location: 11/17

0.00

12 11-4-25

Packaging

Packaging

Memo

030

0.00

*****STOCK IN LARGE FAB*****

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/4/26 J

ME
11-04-26

Picklist Print

Page 1

Monday, April 18, 2011 6:56:01 AM

Work Order ID: 68561



Parent Item: D3407-5



Parent Item Name: Ring

Start Date: 4/18/2011

Required Date: 4/19/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000 17-4 SS Bar .250 X 4.00		Purchased		No		100	f	21.8000	0.2666	6.735158	7.1	18-11-14-18	

Location	Loc Qty	Loc Code
MAT049	4.8	
116835	4.8	
MAT050	17	
117130	17	

$$16836 \times 17 = 4.5 \quad (27)$$

$$117130 \times 10 = 2.6$$

DART AEROSPACE LTD	Work Order:	68561
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

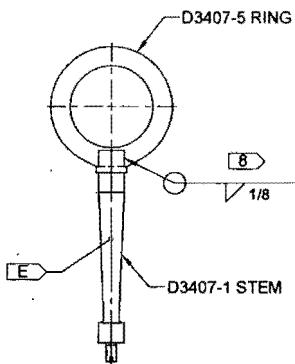
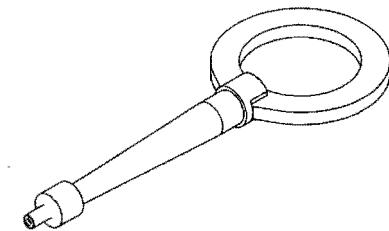
Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-4-18	Date: 11/04/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	
B	07.09.18	Tolerance revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	09.05.04	Dwg Rev updated	KJ/DD	

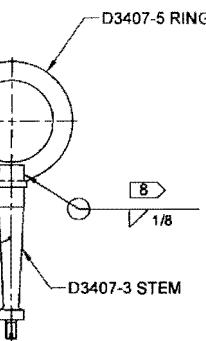
8 7 6 5 4 3 2 1

E

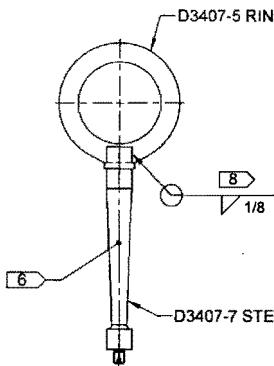
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING E

RELEASED
08-08-01

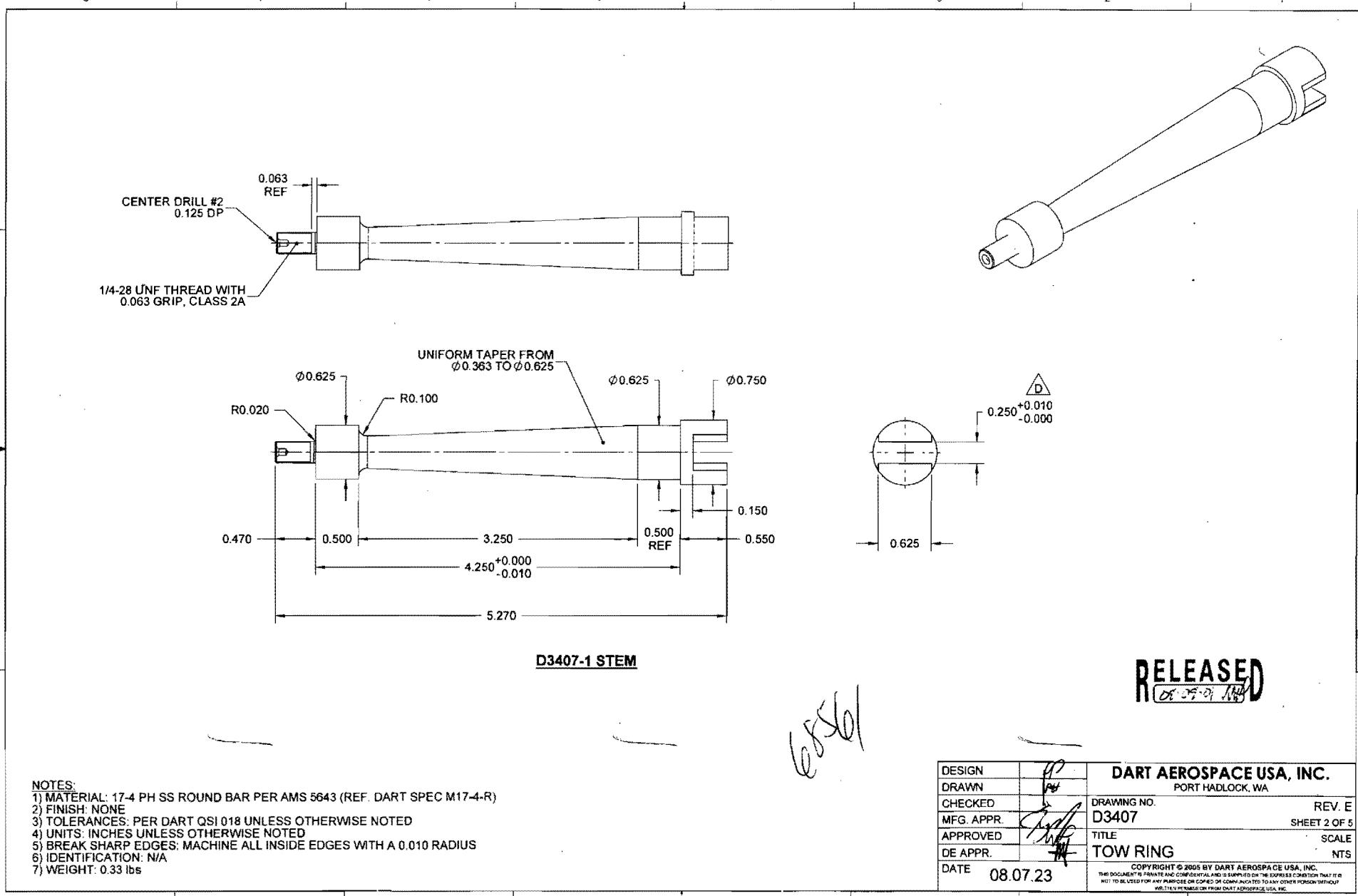
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER E
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

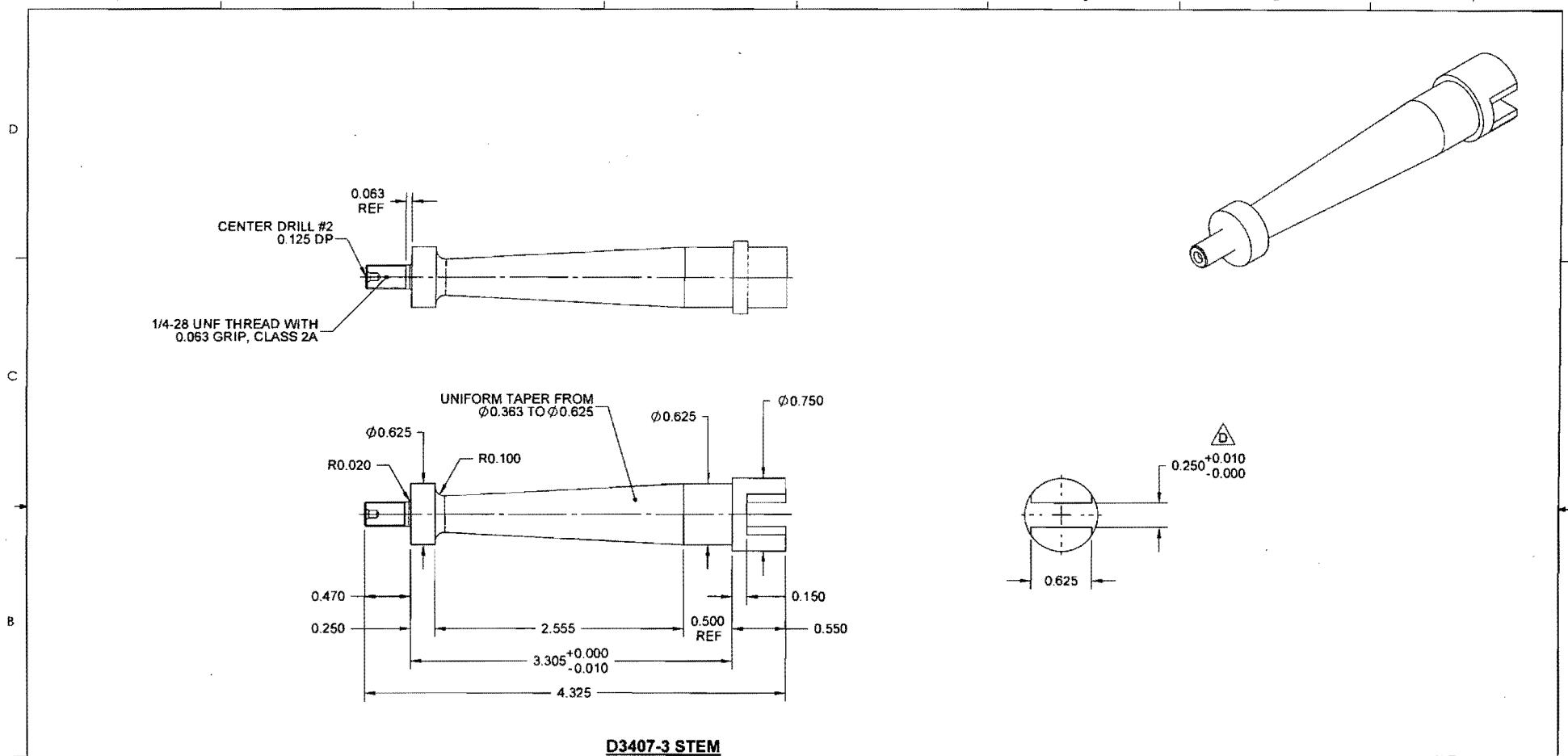
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-1); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	19		
DRAWN	1A		
CHECKED			
MFG. APPR.		DRAWING NO.	REV. E
APPROVED		D3407	SHEET 1 OF 5
DE APPR.		TITLE	SCALE
DATE	08.07.23		NTS

W68561

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8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

68561
RELEASED
06-05-01 MA

DESIGN	9	DART AEROSPACE USA, INC.
DRAWN	per	PORT HADLOCK, WA
CHECKED	5	DRAWING NO. D3407
MFG. APPR.	Sh	REV. E
APPROVED	W	SHEET 3 OF 5
DE APPR.	W	TITLE TOW RING
DATE	08.07.23	SCALE NTS

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8 7 6 5 4 3 2 1

A

